

Work Order ID 139539

Monday, November 30, 2015 11:07:33 AM

139539

Page 1

Item ID: D3977-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bolt
Start Date: 11/30/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/30/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MCS Date: DEC 02 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3977	A								

100

100

Purchasing

Purchasing

Memo

Issue P/O: 30670
Purchase Part Number: 92356A662
Supplier: McMASTER-CARR
Certificate of conformity is required

0.00

0.00

CL DEC 04 2015 4

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

0.00

4x SP15-12-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☒ Engineering ☐ Quality ☐ Other ☐					
Date : 15-12-09		Step #: 100		QTY Effective : 4		MRB (QSI042) Approval			
Description Work Order Deviation				Disposition					
<i>Part is not to drawing</i> <i>Ø.38 is 3/16"</i> <i>Thread length .75" is 6.1/8"</i> <i>DAS 9 989</i>									
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		☒ Supplier		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER: <i>Supplier</i>			
Misidentified ☐		Past Due ☐					

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>47</u>	<u>16-01-05</u>		DAS 9 9-89
130 *130* Small Fab Small Fab Conv Mill	Memo DRILL HOLE AS PER DWG	0.00 0.00				<u>3</u>	<u>1</u>		DAS 45 9-89 2016-01-19 P.T.O.
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>3</u>			DAS 38 9-89 JAN 15 2016

DQA: cut Date: 16/02/09

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed POA Date: 16/02/09Work Order update only ☐

Work Order: <u>139539</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3977-1</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>165584</u>		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>JAN 15 2016</u>		Step #: <u>130</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval DAS 9 9-89 <u>16-01-15</u>		
Description Work Order Deviation				Disposition				Completed By J.C.L. 16-01-18 JAN 15 2016	
while drilling hole bit Broke inside and damage the hole when trying to take it out RC. operators				scrap / destroy no replace				Lead hand / Supervisor Approval Verification 88-6 38 9-89 SVD JAN 15 2016	
								QC / QA Coordinator Approval DAS 9 9-89 <u>16-01-15</u>	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	☒ Pressure/Forced	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	☒ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER: ☐							

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Page 3

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bolt

Stop

NS2

Start Date: 11/30/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: ST007

0.00

150

Packaging

Memo

0.00

Packaging

3DAS
6
9-89

JAN 18 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS

JAN 18 2016

MCS

JAN 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Monday, November 30, 2015 11:07:32 AM

Page 1

Work Order ID: 139539

139539

Parent Item: D3977-1

D3977-1

Parent Item Name: Bolt

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

92356A662

Purchased

No

110

Each

0.0000

1

4

92356A662

Bolt

4X SPD B-12-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

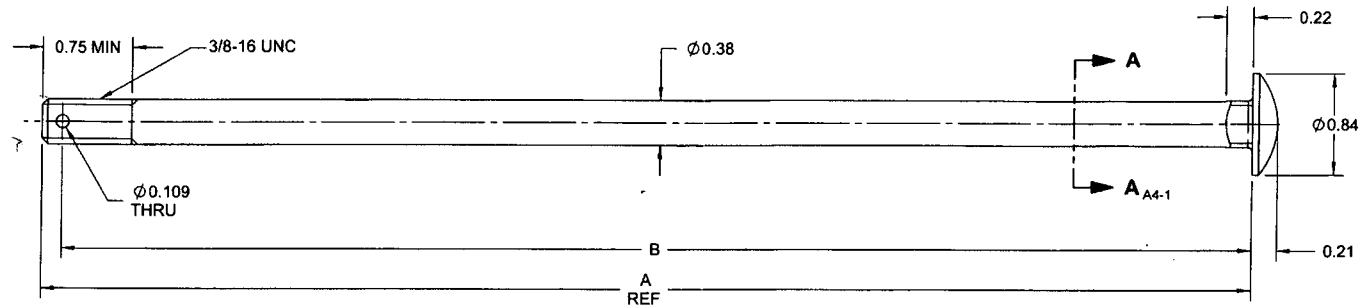
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

SPECIFICATION CONTROL DRAWING



D3977-X BOLT (CARRIAGE), UNC

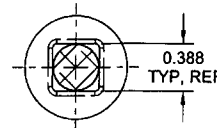
DART P/N	A	B	MATERIAL	WEIGHT (lbs)	SUPPLIER	SUPPLIER P/N
D3977-1	10.00	9.830	18-8 STAINLESS STEEL	0.34	McMASTER-CARR	92356A662

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

No. 139539
MLJ
15-12-02

RELEASE
09/07/13



SECTION A-A C3-1

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: SEE TABLE

A	NEW ISSUE	MB	09.07.13
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3977
REV. A
SHEET 1 OF 1
TITLE BOLT (CARRIAGE), UNC
SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30670**

Purchase Order Date 12/4/2015

PO Print Date 12/4/2015

Page Number 2 of 3

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

3	92311A564	Set Screw	12/8/2015	50.00 ✓	\$0.23	\$11.65
			Yes	Each		
			12/8/2015			

AS PER DWG D3533 REV. B
B139702

Line Total: \$11.65

4	92356A662	Bolt	12/8/2015	4.00 ✓	\$6.23	\$24.92
			Yes	Each		
			12/8/2015			

AS PER DWG D3977 REV. A
B139539

8015-12-08

Line Total: \$24.92

5	91853A031	Nut	12/8/2015	4.00 ✓	\$3.40	\$13.60
			Yes	Each		
			12/8/2015	15/12/18		

AS PER DWG D3978 REV. A
B139521

Line Total: \$13.60

Note:

12/4/2015



Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Chantal

Purchase Order
PO30670

Page 1 of 1

12/04/2015

Order Placed By
Chantal Lavoie

McMaster-Carr Number
4200256-02

Line	Product	Ordered	Shipped
2	✓ 59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	✓ 25 Each	✓ 25 /
3	92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50	1 Pack	1 /
4	92356A662 Type 18-8 Stainless Steel Square Neck Carriage Bolt, 3/8"-16 Thread, 10" Long, Packs of 4	4 Packs	4 /
5	91853A031 Slotted Locknut for Use with Cotter Pins, 18-8 Stainless Steel, 3/8"-16 Thread Size, 9/16" WD, Packs of 1	4 Packs	4 /
6	5862K14 Neodymium Disc Magnet, 1/2" Diameter, with Countersunk Hole for No. 4 Screw Size	1 Each	1 /

Shipped separately from our Chicago warehouse on 12/04

1	3543T25 High-Strength 301 Stainless Steel Sheet, with Certificate, 1/4 Hard, 0.048" Thick, 12" X 12"	1 Each	1
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Notes about your shipment

The U.S. Department of Transportation regulates the shipping of line 6. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.

44102000

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 44834804
Purchase Order: PO30670
Release:
McMaster-Carr Number: 4200256-02

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 04-Dec-2015

FOB: ORIGIN

Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:

Shipping Chantal
Attention:

Contact:

Line	Description	Qty & Unit	Unit Price	Extension
2	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	25 EA	\$17.14	\$428.50
3	92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50 Country of Origin: Taiwan Schedule B #: 731815 ECCN #: EAR99 NLR	1 PK	\$11.50	\$11.50
4	92356A662 Type 18-8 Stainless Steel Square Neck Carriage Bolt, 3/8"-16 Thread, 10" Long, Packs of 1 Country of Origin: Taiwan Schedule B #: 731815 ECCN #: EAR99 NLR	4 PK	\$6.23	\$24.92
5	91853A031 Slotted Locknut for Use with Cotter Pins, 18-8 Stainless Steel, 3/8"-16 Thread Size, 9/16" WD, Packs of 1 Country of Origin: India Schedule B #: 731816 ECCN #: EAR99 NLR	4 PK	\$3.40	\$13.60

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 3	Number of Packages: 1	Invoice Amounts:	Merchandise Amount: \$481.83 Canadian GST/HST: \$64.37 Shipping Charges: \$13.22 Total (In USD): \$559.42
Package Dimensions: 36 X 21 X 11 CM = .008 CUBIC M		Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: 	Date: 04-Dec-2015	Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA (by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg	Title: Operations Mgr.	Page 1 of 2	

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ORIGINAL COMMERCIAL

INVOICE

CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	5862K14 Neodymium Disc Magnet, 1/2" Diameter, with Countersunk Hole for No. 4 Screw Size Country of Origin: Peoples Republic of China Schedule B #: 850511 ECCN #: EAR99 NLR NOTE The U.S. Department of Transportation regulates the shipping of line 6. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws. NOTE Tracking number(s) for this shipment: MFA004554159	1 EA	\$3.31	\$3.31

SP5-12-08



